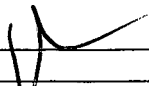
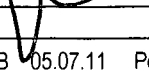


Slip 13/09

Dart Aerospace Ltd.

Date: Wednesday, 12/09/2007 1:30:28 PM
User: Linda Lacelle









Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 34652		
Estimate Number	: 11221		
P.O. Number	: N/A	Part Number	: D3350041
This Issue	: 12/09/2007 S.O. No. : N/A	Drawing Number	: D3350 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 34651	Material	: N/A
Written By	: 	Due Date	: 13/09/2007
Checked & Approved By	: 	Qty:	1 Um: Each
Comment	: Est:B 05.07.11 Powder Coat now done after assembly KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"
  <p>Comment: Qty.: 1.3234 f(s)/Unit Total : 1.3234 f(s) 6061-T6 Bar .75" x .75" Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B0.750x00.750) Identify for D3350-1 Batch: <u>10102476</u></p>		
2.0	BAND SAW	BAND SAW
  <p>Comment: BAND SAW Cut blank: 0.750" x 0.750" x 15.00" long</p>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
  <p>Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3350-1 as per Folio FA496 and Dwg D3350 Identify as D3350-1</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
  <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>		

Date: Wednesday, 12/09/2007 1:30:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 34652

Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

St 07/09/12 (1)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble and Deburr

Jul 07.09.12 (1)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

ml 07/09/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/09/12 (1)

9.0

D23245

Strap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Strap
Pick:
Qty Part Number Description Batch
2 D2324-5 Strap ~~301393~~ B 30139B X2 ✓ ml

10.0

AN312A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
Pick:
Qty Part Number Description Batch
2 AN3-12A Bolt M100188 ✓ ml

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Washer
Pick:
Qty Part Number Description Batch
4 AN960JD10 Washer M104885 ✓ ml 07/09/12

Date: Wednesday, 12/09/2007 1:30:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 34652

Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
2 MS21042L3 Nut (or -3)

M104936

ml 07/09/12

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3350.

Identify as D3350-041 and batch number using a fine point permanent marker

ml 07/09/12^{x1}

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 06/9/12 (41)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

lls 04-09-13 (x1)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/7/13 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

6/7/13 (1)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/09/13 (1)

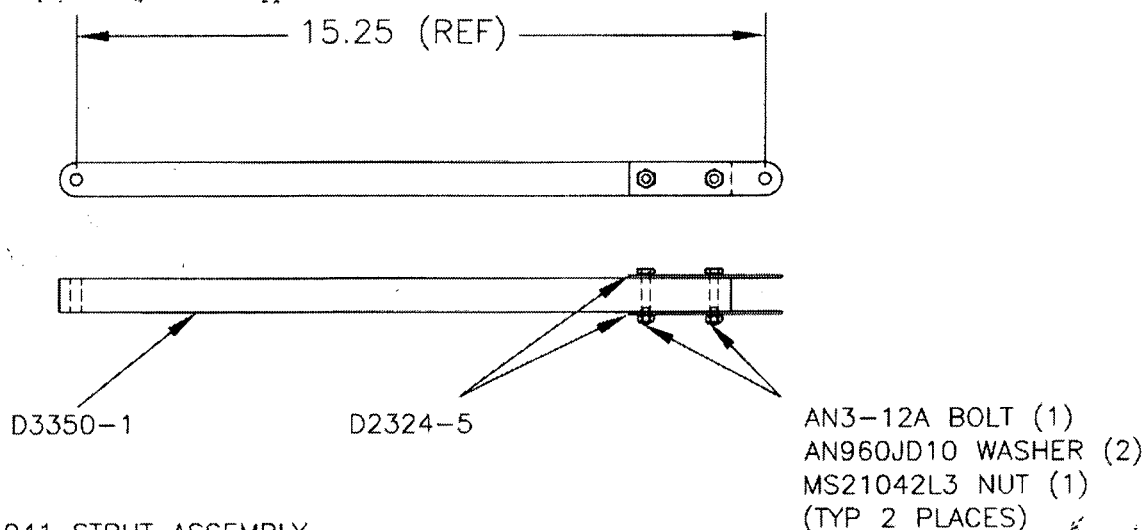
Job Completion



U 07/09/13

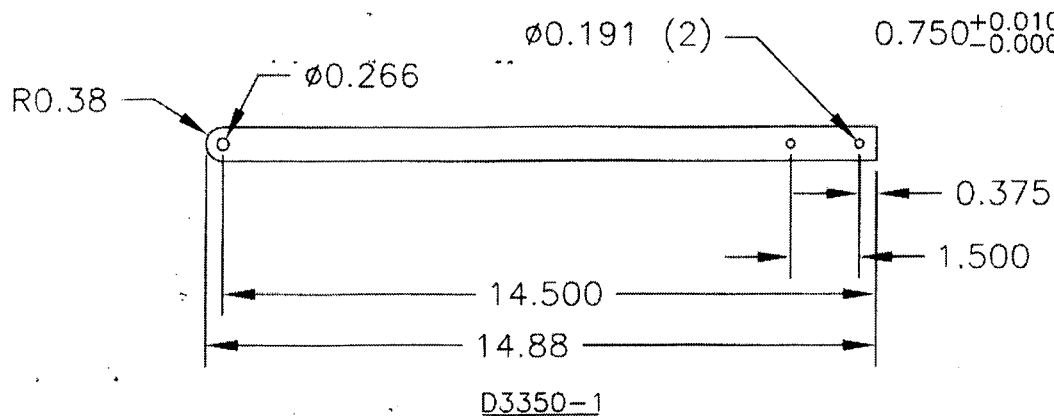


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3350	REV. A SHEET 1 OF 1
DATE 04.11.12		TITLE STRUT	SCALE 1:4
A	04.11.12	NEW ISSUE	



D3350-041 STRUT ASSEMBLY

- 1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

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